

Date: Thursday, 5/3/2007 11:39:33 AM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET ASS'Y
Job Number	32208		
Estimate Number	12523		
P.O. Number	N/A	Part Number	D35313
This Issue	5/3/2007	Drawing Number	UNDER REVIEW
Prsht Rev.	NC	Project Number	N/A
First Issue	N/A	Drawing Revision	N/A
Previous Run	31172	Material	N/A
Written By		Due Date	5/28/2007
Checked & Approved By	<u>John 05.04</u>	Qty:	3
Comment	Est Rev: A New Issue 06-09.06 EC	Um:	Each
<b>Additional Product</b>			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S040	6061-T6 .040 Sheet	
			
Comment: Qty.: 0.1379 sf(s)/Unit Total : 0.4136 sf(s) 6061-T6 .040 Sheet (M6061T6S040) Batch: <u>M100 742</u> <span style="float: right;">SA10 07/05/08</span>			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D3531 Dwg Rev: <u>Prel</u> Prog Rev: <u>Prel</u> <span style="float: right;">SA10 07/05/08 (3)</span>			
2-Deburr if necessary			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;">SA10 07/05/08 (3)</span>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <span style="float: right;">SA10 07/05/08 (3)</span>			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1			
Deburr if necessary. <span style="float: right;">N/A Done @ seq. 2.0</span>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/05/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/08	7.0	Program malfunction hole went to big (one part)	13/04/2	Scrap, destroy and replace	5/05 07/05/08	11 07/05/08	13/04/2	13/04/2

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSY

Job Number: 32208

Part Number: D35313

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3530

3B 07/05/17 (3)

7.0 QC5 INSPECT WORK TO CURRENT STEP



2005-23 (3)



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



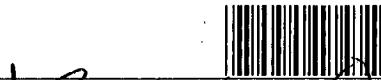
Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD/BL

07/05/24 (3)

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P.7/05/09 (3)

10.0 PACKAGING 1 PACKAGING RESOURCE #1

ENGINEERING  
APPROVAL

y07/05/09

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST/15

P.7/05/09 (3)

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

P.7/05/09 (3)

Job Completion



W.07/05/24

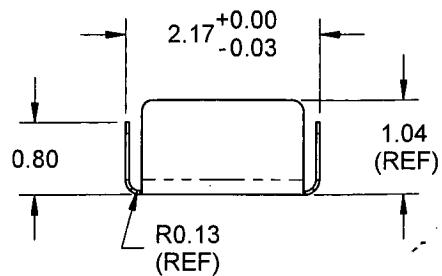
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

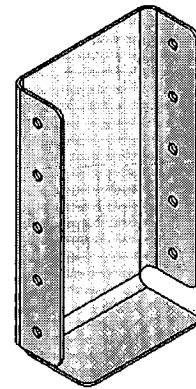
DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. <b>D3531</b>	REV. A SHEET 3 OF 3
DATE 07.01.10		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:2



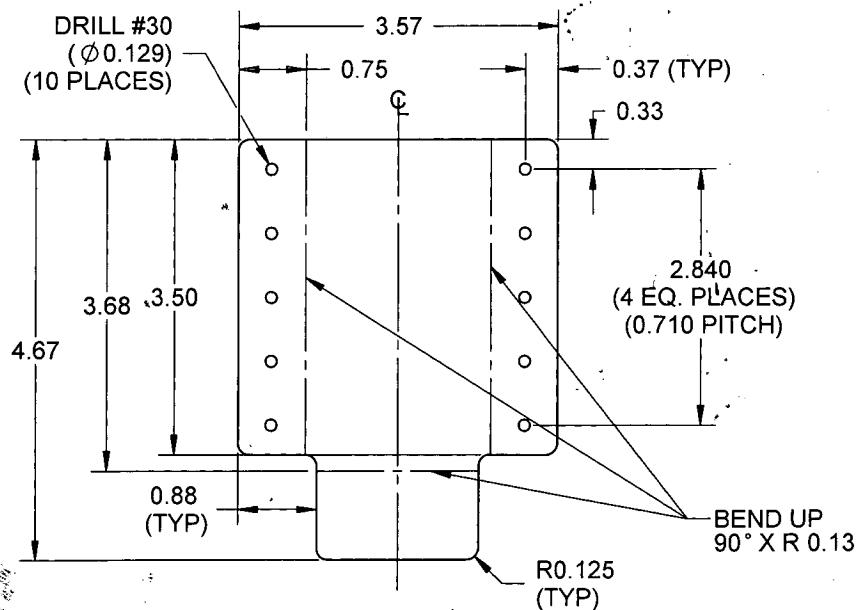
**UNDER REVIEW**

07.05.04 CB

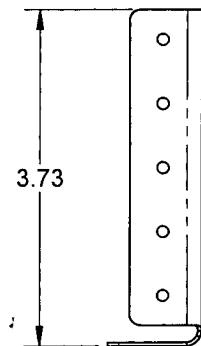
draw not released



**D3531-3 BEND DETAIL**



**D3531-3F FLAT PATTERN**



**D3531-3 BEND DETAIL**

**D3531-3 BRACKET FRONT PLATE**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/1 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\text{C}$

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 32208

DART AEROSPACE LTD

Work Order:

32208

Description: BRACKET ASS'Y

Part Number:

D35313

Inspection Dwg: D35313 Rev: PREL

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

 First Article  Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 4.67	+/-0.030	4.67	✓		Vern	
B 3.50	+/-0.030	3.50	✓		Vern	
C 0.88	+/-0.030	0.87	✓		Vern Vertical	
D 2.840	+/-0.010	2.834	✓		Vern	
E 3.57	+/-0.030	3.57	✓		Vern	
F 0.37	+/-0.030	0.37	✓		Vern	
G 0.33	+/-0.030	0.33	✓		Vern	
H 0.040	+/-0.010	0.038	✓		Vern	
I Ø 0.129	+0.005 -0.001	0.133	✓		Vern	
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	SAY	Audited by:	BF	Prototype Approval:	N/A
Date:	07/05/08	Date:	07-05-08	Date:	07.05.08 N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

